Tuesday, February 01, 2011 7:08:11 AM .

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Page 1

Item ID:

D3391-023

Accept

Setup Start

Revision ID:

Item Name: Mid Tube Assembly

Start Date: 2/1/2011 ' Start Oty: 1.00

Required Date: 2/4/2011

Rea'd Otv: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Date: //- 17-/ Tooling:

SPC (Y/N):

Date:

Date:

Run

Otv

Start

Stop



Stop

Sequence ID/ **Work Center ID** Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Reject

Insp. Number Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

0.00

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" exept for fwd saddle hole of detail

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391



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W/O:			W	ORK ORDER CHANG	ES				۲,
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Tuesday, February 01, 2011 7:08:11 AM

Item ID:

D3391-023

Revision ID:

Item Name:

Mid Tube Assembly

Start Date:

2/1/2011

Start Otv: 1.00

Required Date: 2/4/2011

Rea'd Otv: 1.00



Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Date:

Tooling:

Date:

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

Operation Description

Set Up/ **Run Hours**

SPC (Y/N):

Tool ID

Tool # Plan

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

11-Open .375" holes to .438" ***do not open fwd saddle holes***

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previusly drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previusly tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia in D3391-021

14- Transfer drill 2 wearplate holes into \$3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D\$391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

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Tuesday, February 01, 2011 7:08:11 AM



Page 3

Item ID:

D3391-023

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 2/4/2011

Mid Tube Assembly

Start Date:

2/1/2011

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

110

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code Accept Qty

Reject Oty

Reject Insp. Number Stamp

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

Memo

Memo

0.00

0.00

11-02-01

130

Quality Control

QC3- Inspect Part Finish

0.00

0.00

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Tuesday, February 01, 2011 7:08:11 AM

Item ID: 25 D3391-023

Revision ID:

Item Name:

Mid Tube Assembly

Start Date:

Required Date: 2/4/2011

2/1/2011

Start Qty: 1.00

Req'd Qty: 1.00



Accept



Run

Accept

Qty

Setup Start



Stop

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: ____ ___

Date:

Tooling:

Date:

Tool # Plan

Code

Date:

Start

Reject

Number

Stop

Reject

Qty

Insp.

Stamp

Sequence ID/ **Work Center ID**

140

Skidtubes Skidtubes

Operation Description

Set Up/ **Run Hours**

SPC (Y/N):

0.00

0.00

Skidtubes

Memo

1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg

3- Prepare tube for welding

4-Bond web in place as per Dwg D3391 & QSI 015.

Date: _____

Adhere for 12 hours)

A/R Sikaflex exp: 11-9-3 batch#: M11604()

150

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

160

Skidtubes

Skidtubes

Skidtubes

Memo

Memo

0.00

0.00

1-Weld crossbolt spacer as per dwg D3391 & QSI 004

2-grind weld flush

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W/O:			WO	RK ORDER CHAN	GES				
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Tuesday, February 01, 2011 7:08:11 AM



Page 5

Item ID: **Revision ID:** Item Name:

D3391-023

Required Date: 2/4/2011

Accept

Setup Start

Stop

Start Date:

2/1/2011

Start Otv: 1.00

Reg'd Oty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Mid Tube Assembly

Date:

Tooling:

Date:

Start Run



Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

170

Quality Control

Operation **Description**

QC10- Inspect visual per OSI004- ground welds

Set Up/ Run Hours

Tool ID

Tool # Plan Code

Accept Reject Qty Oty

Reject Number

Insp. Stamp

Memo



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

185

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

Memo

0.00

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BR 11-08-2.

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Tuesday, February 01, 2011 7:08:11 AM

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Item ID:

D3391-023

Accept

Setup Start

Stop



Revision ID:

Item Name:

Mid Tube Assembly

Start Date:

2/1/2011

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Required Date: 2/4/2011

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

Date: Date:

Code

Tool # Plan

Start Stop

Reject

Qty

Run

Accept

Qty



Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

190

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

FINISH TIME:

Date:

200

Quality Control

QC3- Inspect Part Finish

Memo

0.00

11/02/02

0.00

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W/O:			W	ORK ORDER CHANG	ES				, ,
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Tuesday, February 01, 2011 7:08:11 AM



Page 7

Item ID:

D3391-023

Accept



Setup Start



Stop

Start

Revision ID:

Item Name:

Mid Tube Assembly

Start Date:

2/1/2011

Start Qty: 1.00

Required Date: 2/4/2011

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

SPC (Y/N):

Date:

Date:

Qty

Run

Stop

Sequence ID/

Operation **Work Center ID** Description

QC:

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

210

Skidtubes

Skidtubes

Skidtubes

Memo

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

Date:

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" a

per DSI 9364 4- remove T-pins and locate DT9415 from first and third crossbolt hole using Tpins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

220

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:			WO	RK ORDER CHANG	ES				f.
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Tuesday, February 01, 2011 7:08:11 AM

Item ID:

D3391-023

Revision ID:

Item Name:

Mid Tube Assembly

Start Date:

2/1/2011

Start Oty: 1.00

Required Date: 2/4/2011

Req'd Oty: 1.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

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Date: Date:

Tooling:

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Date:

Tool # Plan

Code

Start

Reject

Otv

Stop

Reject

Number



Insp.

Stamp

Sequence ID/ Work Center ID

230



HandFinish

Hand Finishing

Operation Description

HandFinishing

Memo

Install Inserts as per Dwg

Set Up/ Run Hours

11/02/02

Accept

Otv

Run



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

250

Packaging Packaging

Memo

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Item ID:

D3391-023

Tuesday, February 01, 2011 7:08:11 AM

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 2/4/2011

Mid Tube Assembly

Start Date:

2/1/2011

Start Qty: 1.00

Req'd Qty: 1.00

Operation

Description

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date: _____ Tooling: SPC (Y/N): Date:

Date:

Run Start

Stop

Sequence ID/

Work Center ID

260

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Quality Control

Memo

MF 11-02-60

Picklist Print

Tuesday, February 01, 2011 7:08:08 AM

Work Order ID: 65984

Parent Item:

D3391-023

Parent Item Name: Mid Tube Assembly



Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP AI 05.10.20 | New Issue! |

IPP B□06.02.10□ECN773 dwg rev.D

07.03.20 rev F dwg

IPP C IPP D 07.03.28

re-format

IPP E 07.10.31 ecn 1053P

EC EC

KJ/ECH

EC

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IPP Rev:F ECN 1056 07-11-13 DD

verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev: J add in seq 140 expire date & h# sikafley DD 10.02.17 verified by EC

			sikane	X DD 10.02	.17 verified by	:EC							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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Picklist Print									Page 2)
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Parent Item Name: Mid Tube Asse	mbly	1 1401111 1001			•	s	tart Date: 2	/1/2011	Required Date: 2/4/2011	
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Tuesday, February 01, 2011 7:08:08 AM

B (05904 per MB/BB Shop Packet Print)

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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11/02/02	230	*instal with AN3(-4A(X12)/M116075 BOITS (X/2) NAS-1149C0332R/M116025 NUTS	M	nloctor	XIZ					

Part No: _		_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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SHOPCOL RETURN TO **ENGINEERING**

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE WORK ORDER NO 63984

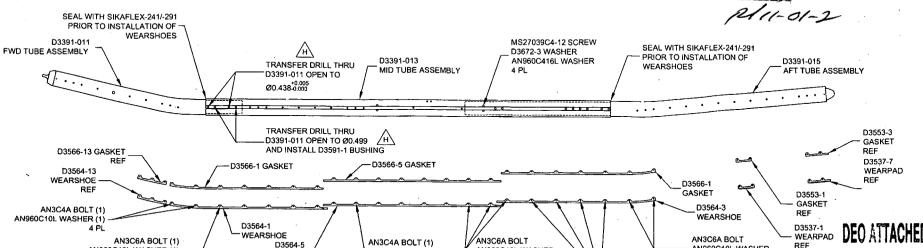
AN960C10L WASHER

AN3C7A BOLT -AN960C10L WASHER

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- AN960C10L WASHER

6 PL

D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

AN960C10L WASHER (1)

2 PL

8

D

	QTY -041	PART NUMBER	DESCRIPTION
	X	D3391-D41	FLOAT SKIDTUBE ASSEMBLY
	1 - 2	D3391-011	FWD TUBE ASSEMBLY
		D3391-013	MID TUBE ASSEMBLY
	1	D3391-015	AFT TUBE ASSEMBLY
		D3564-1	WEARSHOE
	1	D3564-3	WEARSHOE
	1	D3564-5	WEARSHOE
	2	D3566-1	GASKET
\	1	D3566-5	GASKET
\cdot	2	D3591-1	BUSHING
۲.	1	D3572-3	WASHER
	24	AN3C4A	BOLT
	. 12 8	AN3C6A	BOLT
1		AN3C7A	BOLT
	44	AN960C10L	WASHER
- 1	4	MS27039C4-12	SCREW
	4	AN960C416L	WASHER

GENERAL NOTES

WEARSHOE

- CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS, COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

AN960C10L WASHER (1)

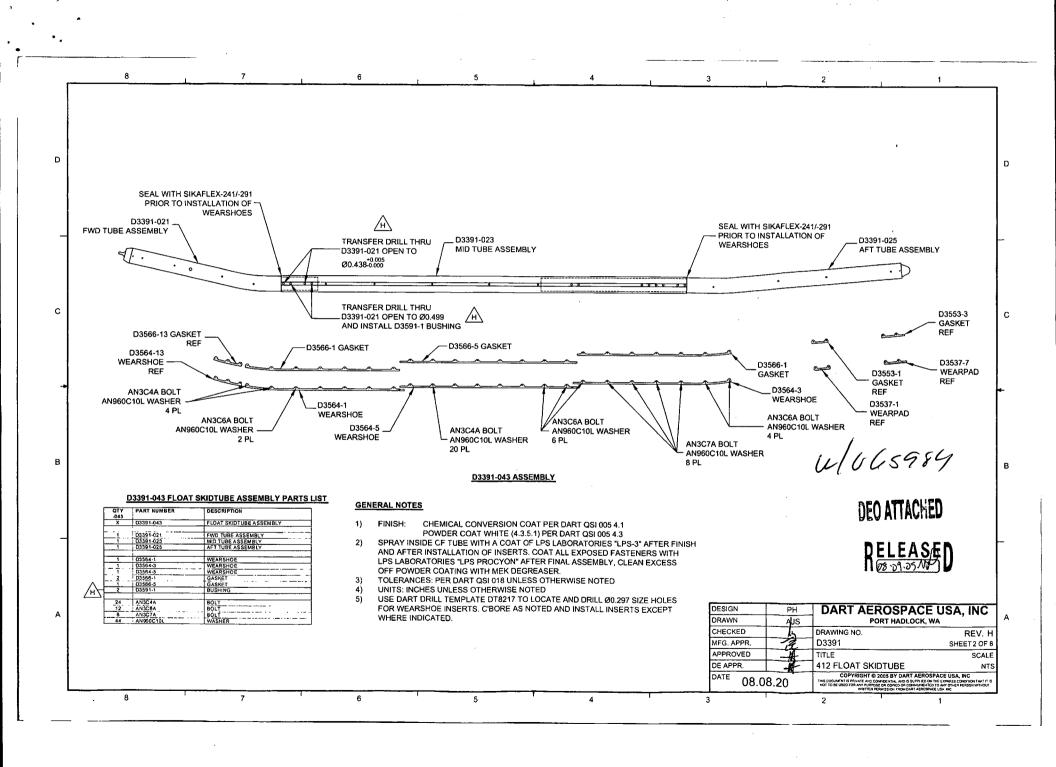
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н	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED Ø3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC .	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
О	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
В	DRAWING UPDATES	PH	05.06.10
Α	NEW ISSUE		05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH DART AEROSPAC	EUS	A. INC

DESIGN	PH	DART AEROSPACE USA, INC				
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MFG. APPR.	B	D3391	SHEET 1 OF 8			
APPROVED	MAN,	TITLE	SCALE			
DE APPR.	7	412 FLOAT SKIDTUBE	NTS			
DATE 08.0	8.20	COPYRIGHT © 2005 BY DART AER THIS COCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED HIGH TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNIC.	ON THE EXPRESS CONDITION THAT IT IS			

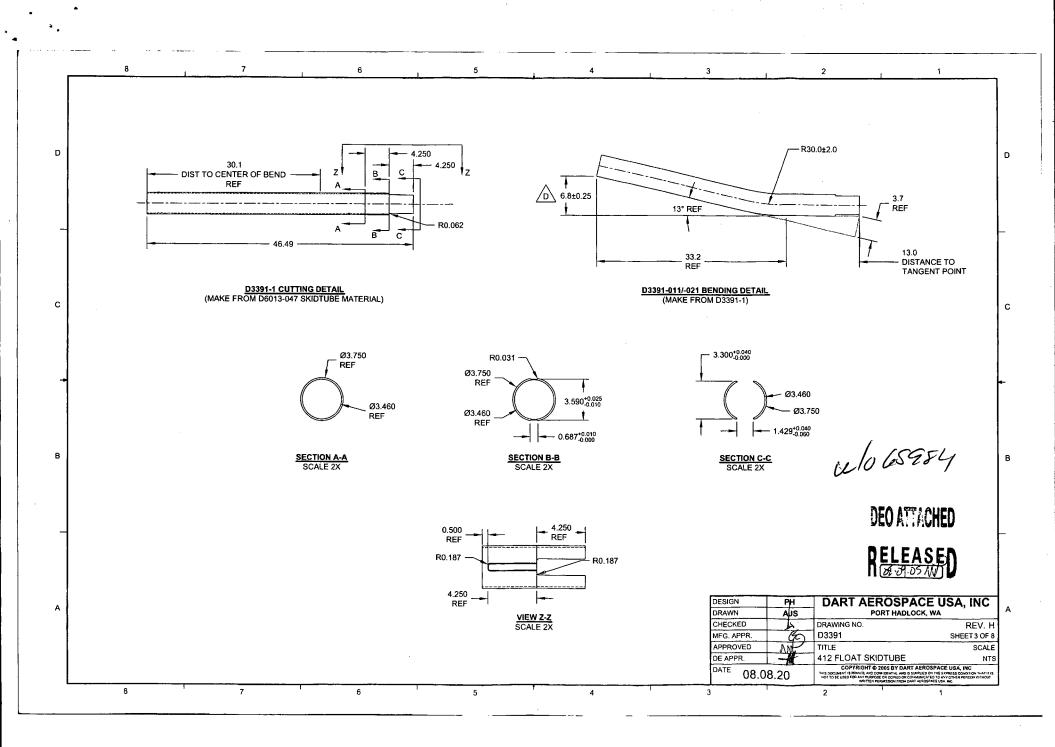
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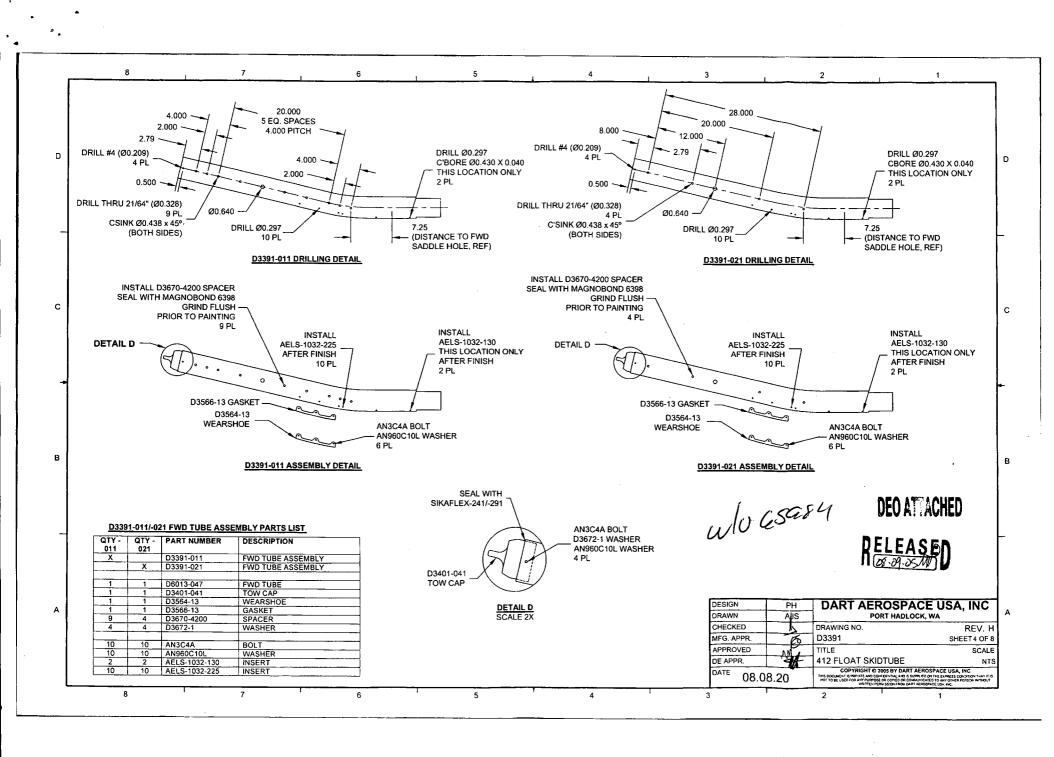


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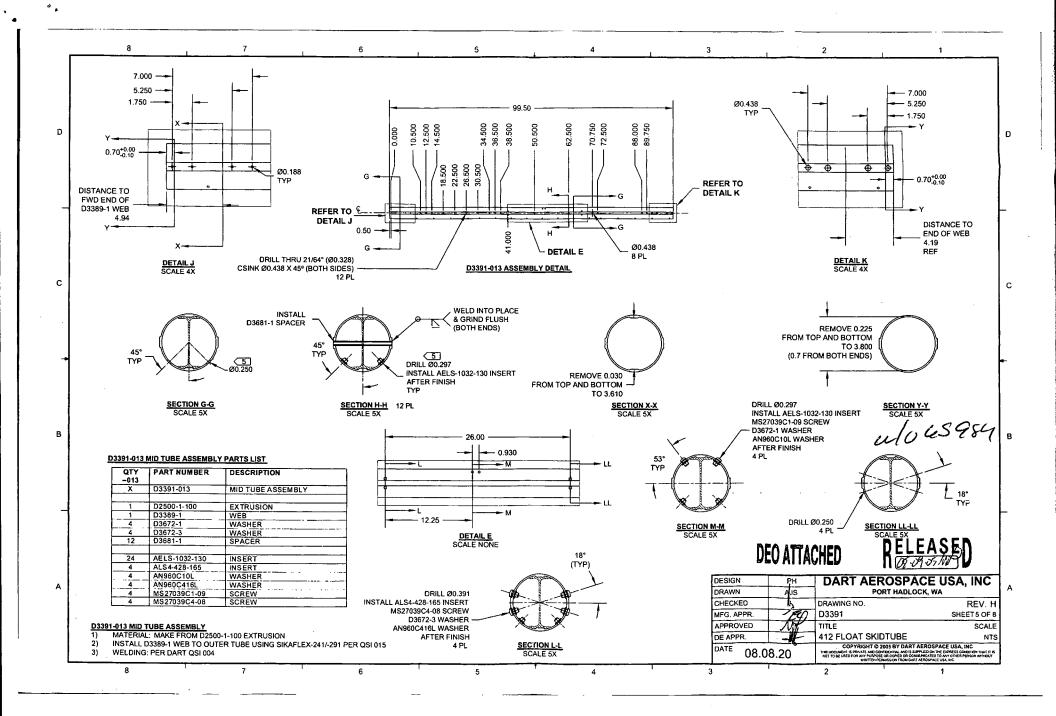


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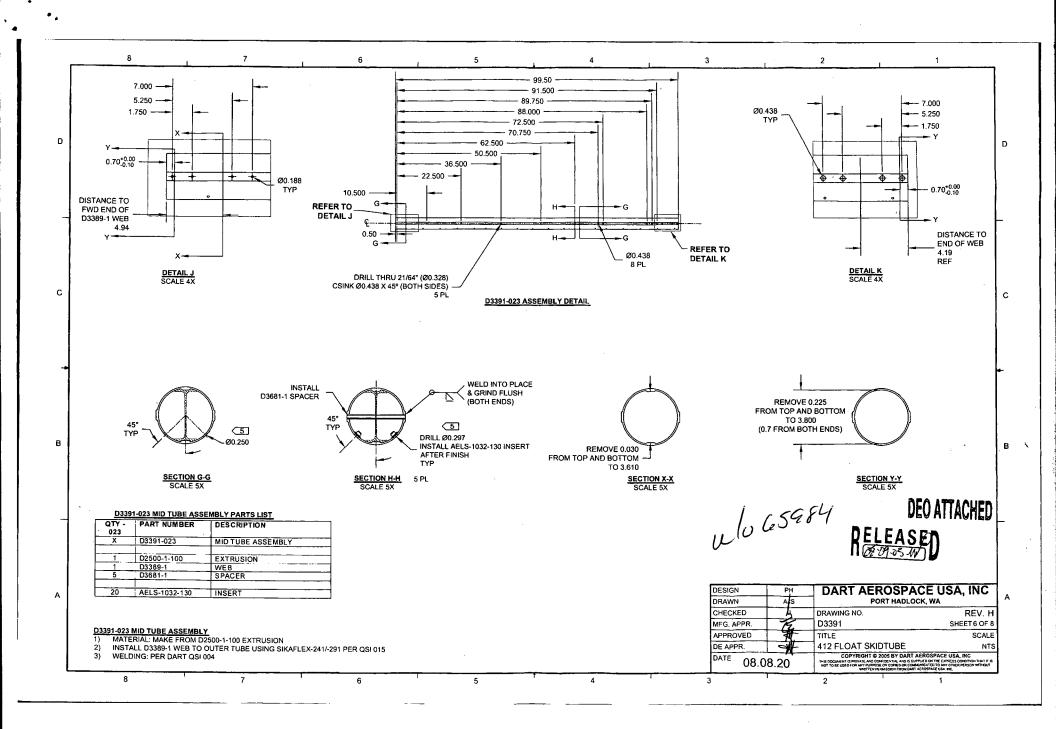
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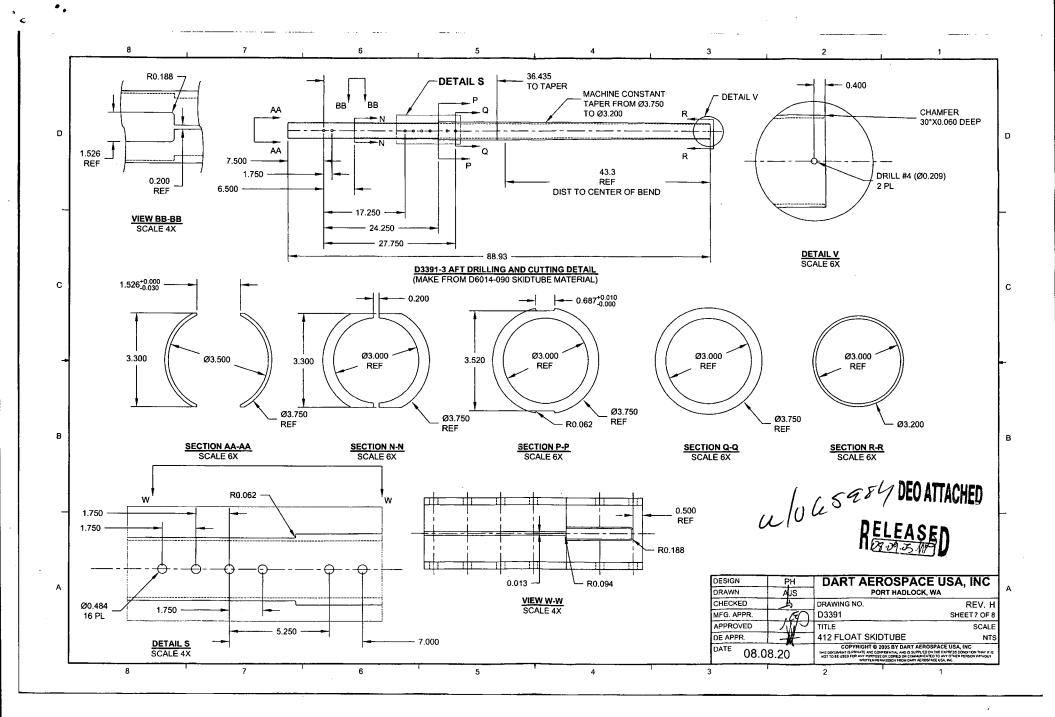


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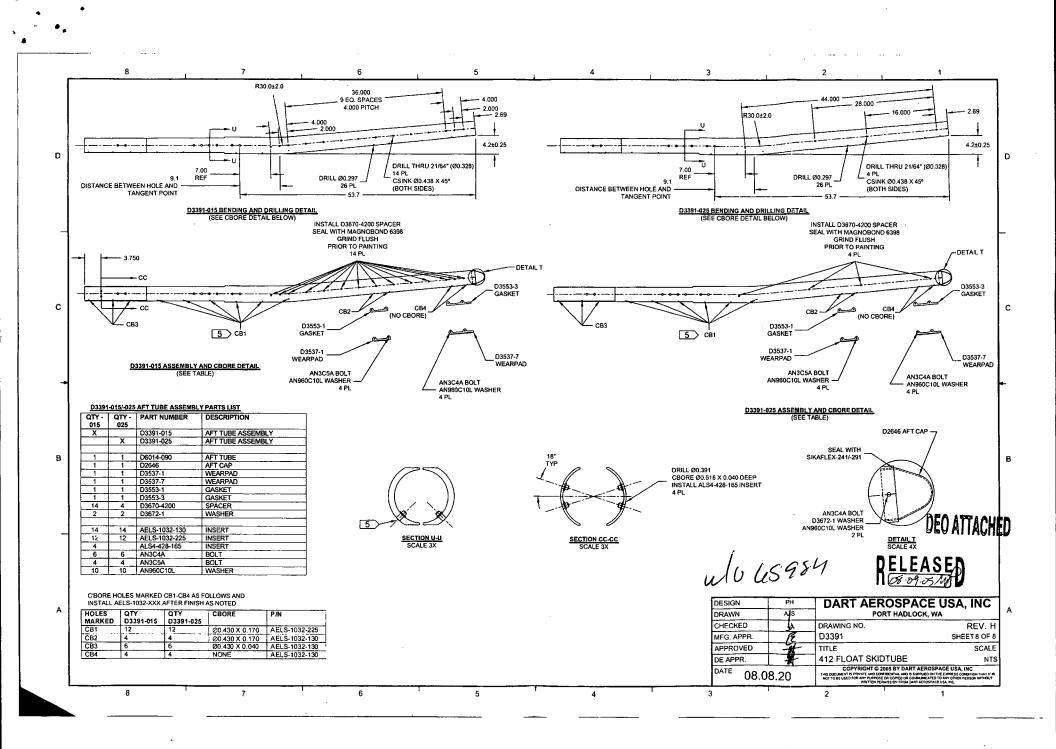
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DRAWING	NO. TITLE		REV. H	DART AEROSPACE	JSA, INC D.E.O. NO.	SHEET NO.	SCALE
D3391	412 FLC	AT SKIDTUBE	ı	ENGINEERING OF	RDER D3391-H-1	SHEET 1 OF,1	NTS
DRAWN	P	CHECKED	Į,	MFG. APPR.	APPROVED MAD	DE APPR.	
DATE	09.09.23	DATE	04.04.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/3	_

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A COAT-OF-LPS LABORATORIES "LPS-3" AFTER FINISH-AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.



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NO. 244

AWS D17.1.2001 QUALIFICATION TEST RECORD

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Name: Darklay Elliott	
Job number: 65322	· · · · · · · · · · · · · · · · · · ·
Part number: 13391-023	
Description: wid tube	
Welding Process: Tig[L] Mig[]	
Base materiel: Alleemenum	
Current: AC[] DC[]	

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[fail[] pass[fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[]
Qualifier fat freum Welder Barry Illiott	Date of Test Coupon // O/ 18 Date of Test Coupon // D/-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld